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IS 10068-5 (1996): Press Working Die Sets (Plain Type),  
Part 5: Rear Post Square Die Sets [PGD 4: Metal Forming  
Machines]

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प्रेस प्रचालन डाई समुच्चय (सादा टाइप)

भाग 5 पश्च पोस्ट वर्गाकार डाई समुच्चय — विशिष्टि

*Indian Standard*

# PRESS WORKING DIE SETS (PLAIN TYPE)

## PART 5 REAR POST SQUARE DIE SETS — SPECIFICATION

ICS 25.120.10

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BUREAU OF INDIAN STANDARDS  
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NEW DELHI 110002

## FOREWORD

This Indian Standard (Part 5) was adopted by the Bureau of Indian Standards, after the draft finalized by the Metal Forming Machines Sectional Committee had been approved by the Production Engineering Division Council.

The die sets covered in this standard are generally used in Indian industry.

While preparing this standard, assistance has been derived from the data supplied by leading manufacturers and users of the product.

This standard (Part 5) is one of the parts of the standard on Press working die sets. The other parts of this standard are as follows:

IS 10068 (Part 1) : 1982 Press working die sets (plain type): Part 1 Centre post rectangular die sets

IS 10068 (Part 2) : 1982 Press working die sets (plain type): Part 2 Centre post square die sets

IS 10068 (Part 3) : 1990 Press working die sets (plain type): Part 3 Centre post round die sets

IS 10068 (Part 4) : 1996 Press working die sets (plain type): Part 4 Rear post rectangular die sets — Specification

IS 10068 (Part 6) : 1996 Press working die sets (plain type): Part 6 Rear post round die sets — Specification

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

## Indian standard

# PRESS WORKING DIE SETS (PLAIN TYPE)

## PART 5 REAR POST SQUARE DIE SETS — SPECIFICATION

### 1 SCOPE

This standard (Part 5) covers dimensions, material and other requirements for plain type rear post square die sets with two guide posts at the rear.

### 2 REFERENCES

The following standards contain provisions which through reference in this text, constitute provision of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below:

IS No.	Title
210 : 1993	Grey iron castings (fourth revision)
1030 : 1989	Carbon steel castings for general engineering purposes (fourth revision)
2062 : 1992	Steel for general structural purposes (fourth revision)
2102 (Part 1) : 1993	General tolerances: Part 1 Tolerances for linear and angular dimensions without individual tolerances indication (third revision)
7664 : 1979	Guide posts for press tool sets (first revision)
8127 : 1979	Guide bushes for press tool sets (first revision)

### 3 TYPES

The rear post square die sets shall be of the following types:

- a) Type A — without tapped hole for shank, and
- b) Type B — with tapped hole for shank.

### 4 MATERIAL

The top and bottom tool holders shall be of cast iron of grade GG 260 of IS 210 : 1993 or cast steel of grade 23-45 of IS 1030 : 1989 or mild steel of IS 2062 : 1992.

### 5 DIMENSIONS

The dimensions of rear post square die sets shall be as given in Table 1.

### 6 GENERAL REQUIREMENTS

The top and bottom tool holders shall be free from cracks, burrs and pits.

### 7 DESIGNATION

A rear post square die set shall be designated by:

- a) Its type;
- b) Material (C for cast iron, S for cast steel, and M for mild steel);
- c) Die space;
- d) Type of guide post;
- e) Type of guide bush; and
- f) Number of this standard.

*Example:*

A rear post square die set Type A of cast iron having a die space  $a_1 \times a_1 = 100 \text{ mm} \times 100 \text{ mm}$  with guide posts of Type B with round end and having length  $l = 150 \text{ mm}$  and with guide bushes of Type B of length  $l = 50 \text{ mm}$  fitted in, shall be designated as:

Die Set IS 10068 (Part 5) - AC 100 × 100 along with Guide Posts IS 7664 - BR 16 × 150 and Guide Bushes IS 8127 - B 16 × 50

### 8 MARKING

8.1 Each die set shall be marked with its designation and manufacturer's trade-mark at a prominent place on tool holders.

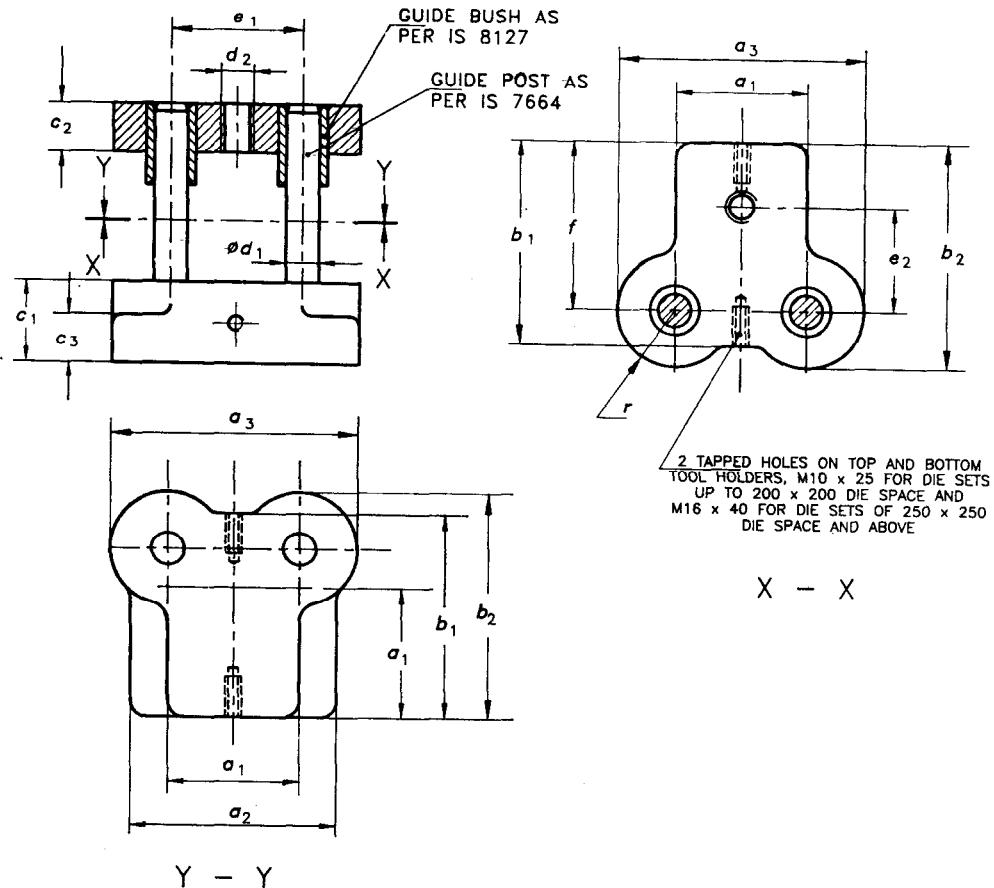
#### 8.2 BIS Certification Marking

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**Table 1 Dimensions for Rear Post Square Die Sets**  
(Clause 5)

All dimensions in millimetres.



Die Space $a_1 \times a_1$	$a_2$	$a_3$	$b_1$	$b_2$	$c_1$	$c_2$	$c_3$	$d_1$	$d_2$	$e_1$	$e_2$	$f$	$r$
50 x 50	90	106	88	96	40	25	20	16	M16 x 1.5	50	43	68	28
63 x 63	103	119	102	110	40	25	20	16	M16 x 1.5	63	50	82	28
80 x 80	125	150	126	139	50	30	30	20	M20 x 1.5	80	64	104	35
100 x 100	145	176	148	164	50	32	25	16	M20 x 1.5	100	76	126	38
125 x 125	170	201	174	190	50	32	30	25	M20 x 1.5	125	89	152	38
160 x 160	205	246	212	233	56	40	30	32	M24 x 1.5	160	110	190	43
200 x 200	245	286	252	278	56	40	30	32	M24 x 1.5	200	130	230	43
250 x 250	295	350	307	335	56	50	30	40	M30 x 2	250	160	285	50
315 x 315	365	415	376	401	63	50	30	40	M30 x 2	315	193	351	50
400 x 400	460	514	470	497	63	60	30	50	M42 x 3	400	240	440	57
500 x 500	560	614	510	597	75	60	30	50	M42 x 3	500	290	540	57

NOTE — Dimensional deviation for untoleranced dimensions shall be of medium class according to IS 2102 (Part 1) : 1993.

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Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Handbook' and 'Standards Monthly Additions'.

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### **Amendments Issued Since Publication**

Amend No.	Date of Issue	Text Affected

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